

**Work Order ID 56717**

March 5, 2010 9:59:52 AM



Page 1

Item ID: D412-742-041

Accept



Setup Start



Revision ID:

Item Name: Replacement Float Skidtube

Stop



Start Date: 05/03/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 17/03/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date: 10-3-5 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC:

Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3391

Rev H

100



DC

Document Control

DOCUMENT CONTROL

0.00

Memo

0.00

If D412-742-041 is a W/O on its own,  
Photocopy bluefile and create labels per PPP D412-742-041 CHG004

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 56717**

March 5, 2010 9:59:52 AM



Page 2

Item ID: D412-742-041

Accept



Setup Start



Revision ID:

Item Name: Replacement Float Skidtube

Stop



Start Date: 05/03/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 17/03/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center ID

110



HandFinish

Hand Finishing

Operation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

=) M 10/07/19

X1 Q

HandFinishing

0.00

Memo

1-Install tubes together and seal them all the way around using Sikaflex

241/291. Ensure tube ends line-up with saddle holes for proper alignment. using

7/16" "T" Pins.

A/R  Sikaflex-241/-291 M115114Expiry date: 11/10/12-Install wearplates as per Dwg D3391. Ensure that plastic washers are against  
wearplate, then topped with the SS washer. Seal all bolts with sikaflex except  
ones with inserts on inside of tube, hand tighten only bolts with no sikaflex.A/R  Sikaflex-241/-291 M115114Expiry date: 11/10/1

3-Remove "T" pins once sikaflex is dry.

4-Coat all exposed hardware with LPS Procyon. Remove any excess off with

MEK degreaser.

A/R  LPS Procyon M104251

Pto →

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Σ w07120

60

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D412-742-041 PAR #: \_\_\_\_\_ Fault Category: sketches NCR: Yes  DQA: \_\_\_\_\_ Date: 10/7/27  
 Resolution: rework Disposition: rework QA: N/C Closed: Clear Date: 10/7/27

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.07.19	110	Fwd saddle holes don't allow bolt to install R.C. Process	<i>JP</i> 10.07.19 per AS1042	Acceptable to file inner holes to allow proper assembly.	<i>JP</i> 10.07.19	<i>S</i> 10/07/20	<i>JP</i> 10.07.19 AS1042	<i>S</i> 10/07/20

NOTE: Date & initial all entries

**Work Order ID 56717**

March 5, 2010 9:59:52 AM



Page 3

Item ID: D412-742-041

Accept



Setup Start



Revision ID:

Item Name: Replacement Float Skidtube

Start Date: 05/03/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 17/03/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

130



Packaging

Packaging

140



QC

Quality Control

Operation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPP D412-742-  
041  Location: \_\_\_\_\_  PPP Rev:

PPP 56721

Co op/23 C

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/07/2010

MF

10-7-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

March 5, 2010 9:59:48 AM

Page 10  
1  
9

Work Order ID: 56717



Parent Item: D412-742-041



Parent Item Name: Replacement Float Skidtube

Start Date: 05/03/2010

Required Date: 17/03/2010

Comments: IPP, Rev A  05.10.13  New Issue  
IPP, Rev B  06.02.13  ECN 773 dwg @ rev.D  
IPP, Rev:C 07-05-28 As per Rev F  
IPP, rev D 07.11.01 ecn 1053p

KJ/JLM   
EC  
JLM  
EC

Start Qty: 1.00

Required Qty: 1.00

AN3C4A



Purchased No

110 Each 1,649.000 24.0000



BOLT

X

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST	1649	M114941
112314	13	111482
112720	12	
112724	3	
112829	1	
112991	2	
113121	64	
113226	344	
113644	110	
113749	100	
114103	500	
114108	500	

X24 M1 1010719

AN3C6A



Purchased No

110 Each 718.0000 12.0000



BOLT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST	718	
(111982)	718	

X1261 1010719

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

March 5, 2010 9:59:48 AM

Page 11 2

Work Order ID: 56717



Parent Item: D412-742-041



Parent Item Name: Replacement Float Skidtube

Start Date: 05/03/2010

Required Date: 17/03/2010

Comments: IPP Rev A 05.10.13 New Issue  
IPP Rev B 06.02.13 ECN 773 dwg @ rev.D  
IPP Rev:C 07-05-28 As per Rev F  
IPP rev D 07.11.01 ecn 1053p

KJ/JLM  
EC  
JLM  
EC

Start Qty: 1.00

Required Qty: 1.00

AN3C7A



Purchased No

110 Each 485.0000 8.0000



BOLT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Main Warehouse

ST	485	
105906	21	
107376	252	
113149	212	

x 8 M 10/09/19

AN960C10L



Purchased No

110 Each 388.0000 44.0000



washer N A S 1 1 4 9 C 0 3 3 Z R

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

OFFSHORE

FG	100	M 115000
103585	100	

x 4 M 10/09/19

Main Warehouse

ST	288	
112116	128	
112612	160	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

March 5, 2010 9:59:48 AM

Page 12  
3

Work Order ID: 56717



Parent Item: D412-742-041



Parent Item Name: Replacement Float Skidtube

Start Date: 05/03/2010

Required Date: 17/03/2010

Comments: IPP Rev A  05.10.13  New Issue  
IPP Rev B  06.02.13  ECN 773 dwg @ rev.D  
IPP Rev:C 07-05-28 As per Rev F  
IPP rev D 07.11.01 ecn 1053p

KJ/JLM   
EC  
JLM  
EC

Start Qty: 1.00

Required Qty: 1.00

AN960C416L



Purchased No

110 Each 1,314.000 4.0000



WASHER

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

OFFSHORE

FG 44

104925 44

Main Warehouse

ST 1270

111916 2

112612 368

112794 500

112828 400

X4 81 10/07/19

D3391-011



Manufactured No

Fwd Tube Assembly

D3391-013



Manufactured No

Mid Tube Assembly

D3391-015



Manufactured No

Aft Tube Assembly



110 Each 0.0000 1.0000

X1 B56726 81 10/07/19

110 Each 0.0000 1.0000

X1 B56729 81 10/07/19

110 Each 0.0000 1.0000

X1 B56732 81 10/07/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

March 5, 2010 9:59:48 AM

Page 13  
4

Work Order ID: 56717



Parent Item: D412-742-041



Parent Item Name: Replacement Float Skidtube

Start Date: 05/03/2010

Required Date: 17/03/2010

Comments: IPP Rev A 05.10.13 New Issue  
IPP Rev B 06.02.13 ECN 773 dwg @ rev.D  
IPP Rev:C 07-05-28 As per Rev F  
IPP rev D 07.11.01 ecn 1053p

KJ/JLM

EC

JLM

EC

Start Qty: 1.00

Required Qty: 1.00

D3564-1



Manufactured No

110

Each

18.0000

1.0000



Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	2	
33798	2	
Main Warehouse		
ST	16	
47531	1	
50270	1	
51676	14	X(41) 10102119

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

March 5, 2010 9:59:48 AM

Page 14  
5

Work Order ID: 56717



Parent Item: D412-742-041



Parent Item Name: Replacement Float Skidtube

Start Date: 05/03/2010

Required Date: 17/03/2010

Comments:

IPP Rev A 05.10.13 New Issue  
IPP Rev B 06.02.13 ECN 773 dwg @ rev.D  
IPP Rev:C 07-05-28 As per Rev F  
IPP rev D 07.11.01 ecn 1053p

KJ/JLM

EC

JLM

EC

Start Qty: 1.00

Required Qty: 1.00

D3564-3



Manufactured No

110

Each

19.0000

1.0000



Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	2	
33764	2	
Main Warehouse		
FP	5	
50113	5	
Main Warehouse		
FP19	11	
55489	11	x181 10/07/19
Main Warehouse		
ST	1	
46445	1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

March 5, 2010 9:59:48 AM.

Page 15  
6

Work Order ID: 56717



Parent Item: D412-742-041



Parent Item Name: Replacement Float Skidtube

Start Date: 05/03/2010

Required Date: 17/03/2010

Comments:

IPP Rev A 05.10.13 New Issue

KJ/JLM

Start Qty: 1.00

IPP Rev B 06.02.13 ECN 773 dwg @ rev.D

EC

Required Qty: 1.00

IPP Rev:C 07-05-28 As per Rev F

JLM

IPP rev D 07.11.01 ecn 1053p

EC

D3564-5



Manufactured No

110

Each

36.0000

1.0000



Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

OFFSHORE

358709

FG

2

X1 Y1 1010719

34806

2

Main Warehouse

FP19

32

51925

1

54772

6

55024

12

55333

13

Main Warehouse

ST

2

45824

1

47433

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

March 5, 2010 9:59:48 AM

Page 16  
7

Work Order ID: 56717



Parent Item: D412742-041



Parent Item Name: Replacement Float Skidtube

Comments: IPP Rev A □ 05.10.13 □ New Issue □  
IPP Rev B □ 06.02.13 □ ECN 773 dwg @ rev.D  
IPP Rev:C 07-05-28 As per Rev F  
IPP rev D 07.11.01 ecn 1053p

KJ/JLM□  
EC  
JLM  
EC

Start Date: 05/03/2010

Required Date: 17/03/2010

Start Qty: 1.00

Required Qty: 1.00

D3566-1



Manufactured No

110

Each

23.0000

2.0000



Gasket

Warehouse      Loc Qty      Loc Code

Location

Main Warehouse

FP	18	359124	XZ 4/10/07 119
52512	3		
54480	1		
55011	1		
55320	13		

Main Warehouse

ST	5		
46349	1		
51218	1		
51259	3		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

March 5, 2010 9:59:48 AM

Page 17  
8

Work Order ID: 56717



Parent Item: D412-742-041



Parent Item Name: Replacement Float Skidtube

Start Date: 05/03/2010

Required Date: 17/03/2010

Comments:

IPP Rev A□05.10.13□New Issue□  
IPP Rev B□06.02.13□ECN 773 dwg @ rev.D  
IPP Rev:C 07-05-28 As per Rev F  
IPP rev D 07.11.01 ecn 1053p

KJ/JLM□  
EC  
JLM  
EC

Start Qty: 1.00

Required Qty: 1.00

D3566-5



Manufactured No

110 Each 26.0000 1.0000



Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

FP19	22	1359158
55026	10	
55335	12	

X1 H1 100719

Main Warehouse

ST	4	
36113	1	
46186	1	
47318	1	
51260	1	

\_\_\_\_\_

D3591-1



Manufactured No

110 Each 37.0000 2.0000



Bushing

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST	37	1357350
46105	29	
47121	8	

X1 H1 100719

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

March 5, 2010 9:59:48 AM

Page 18  
29

Work Order ID: 56717



Parent Item: D412742-041



Parent Item Name: Replacement Float Skidtube

Start Date: 05/03/2010

Required Date: 17/03/2010

Comments:

IPP Rev A □ 05.10.13 □ New Issue □  
IPP Rev B □ 06.02.13 □ ECN 773 dwg @ rev.D  
IPP Rev:C 07-05-28 As per Rev F  
IPP rev D 07.11.01 ecn 1053p

KJ/JLM □

EC

JLM

EC

Start Qty: 1.00

Required Qty: 1.00

D3672-3



Manufactured No

110

Each

524.0000 4.0000



Phenolic Washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST117

24

B57704

X1 10 107119

51596

24

Main Warehouse

ST77

500

55560

500

MS27039C4-12



Purchased No

110

Each

22.0000 4.0000



SCREW

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST

22

M1114221

X2 10 107119

12726

4

2296

2

5558

16

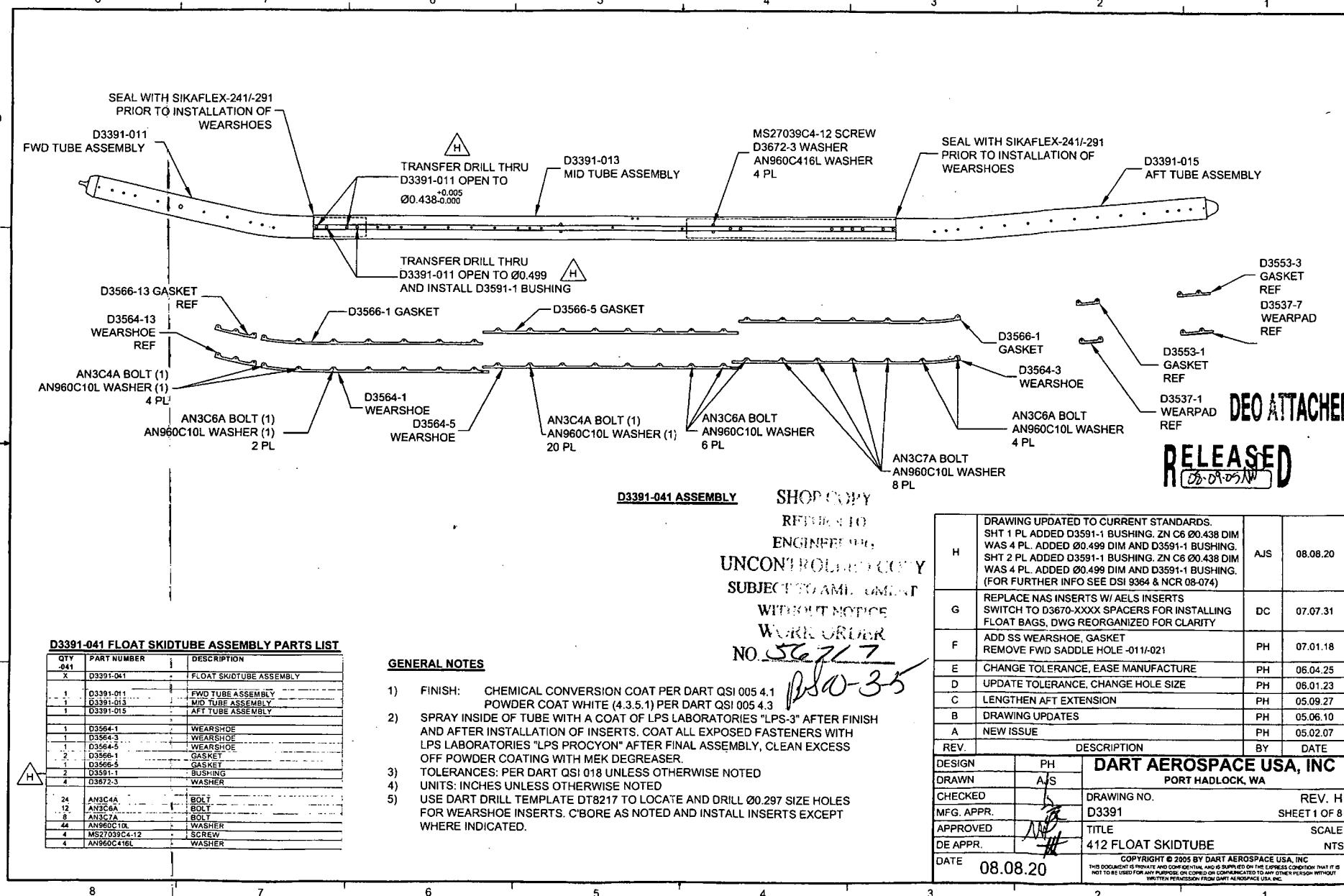
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

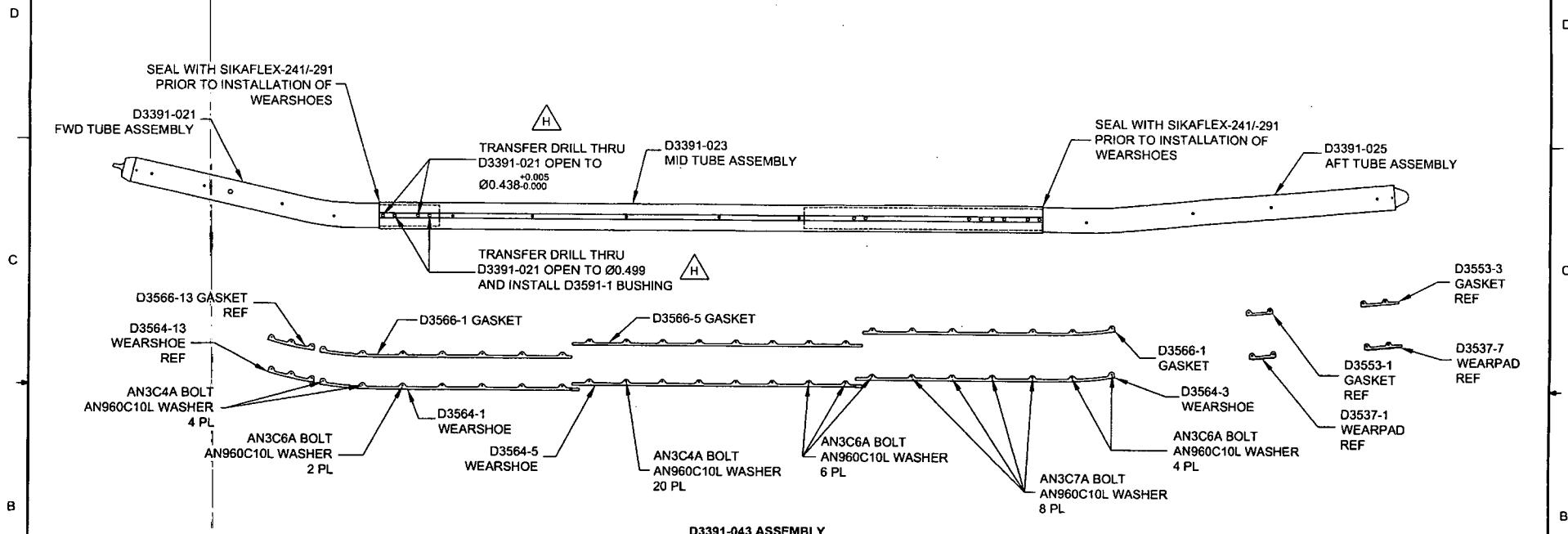
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



8 7 6 5 4 3 2 1



#### D3391-043 ASSEMBLY

#### D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
2	D3564-5	GASKET
1	D3566-5	WEARSHOE
2	D3591-1	BUSHING
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

#### GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH  
AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH  
LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS  
OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES  
FOR WEARSHOE INSERTS. CBORE AS NOTED AND INSTALL INSERTS EXCEPT  
WHERE INDICATED.

DETACHED

RELEASED  
08.08.20

DESIGN	PH
DRAWN	AUS
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DRAWING NO. REV. H	
D3391 SHEET 2 OF 8	
TITLE	
SCALE	
412 FLOAT SKIDTUBE NTS	
DATE 08.08.20	

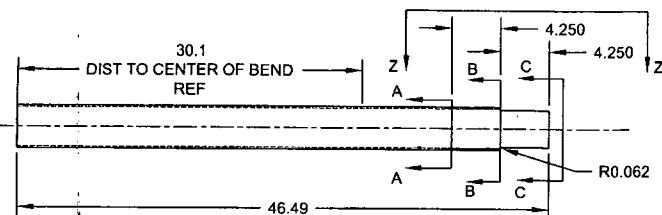
COPYRIGHT © 2005 BY DART AEROSPACE USA, INC.  
THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE USA, INC. IT IS  
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  
WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

8 7 6 5 4 3 2 1

A

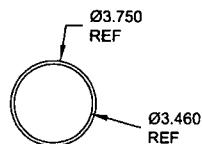
8 7 6 5 4 3 2 1

D

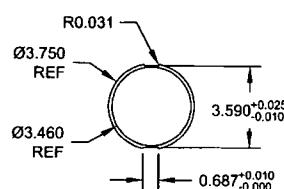


**D3391-1 CUTTING DETAIL**  
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)

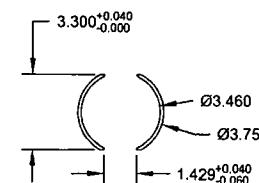
C



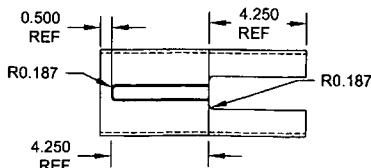
**SECTION A-A**  
SCALE 2X



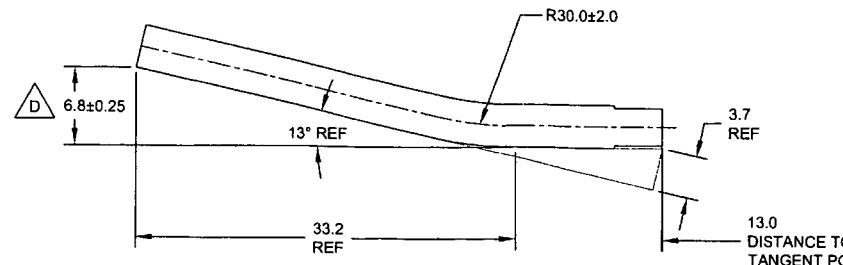
**SECTION B-B**  
SCALE 2X



**SECTION C-C**  
SCALE 2X



**VIEW Z-Z**  
SCALE 2X



**D3391-011/-021 BENDING DETAIL**  
(MAKE FROM D3391-1)

B

A

DE ATTACHED

RELEASED  
*w656717*

DESIGN	PH	<b>DART AEROSPACE USA, INC</b>
DRAWN	AUS	PORT HADLOCK, WA
CHECKED	<i>b</i>	DRAWING NO.
MFG. APPR.	<i>b</i>	REV. H
APPROVED	<i>AN</i>	SHEET 3 OF 8
DE APPR.	<i>AN</i>	TITLE
DATE	08.08.20	SCALE
		412 FLOAT SKIDTUBE
		NTS

COPYRIGHT © 2005 BY DART AEROSPACE USA, INC.  
THIS DOCUMENT IS PROPRIETARY AND IS SUPPLIED UNDER THE EXPRESS CONDITION THAT IT IS  
NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COPIED TO ANY OTHER PERSON WITHOUT  
WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

8

7

6

5

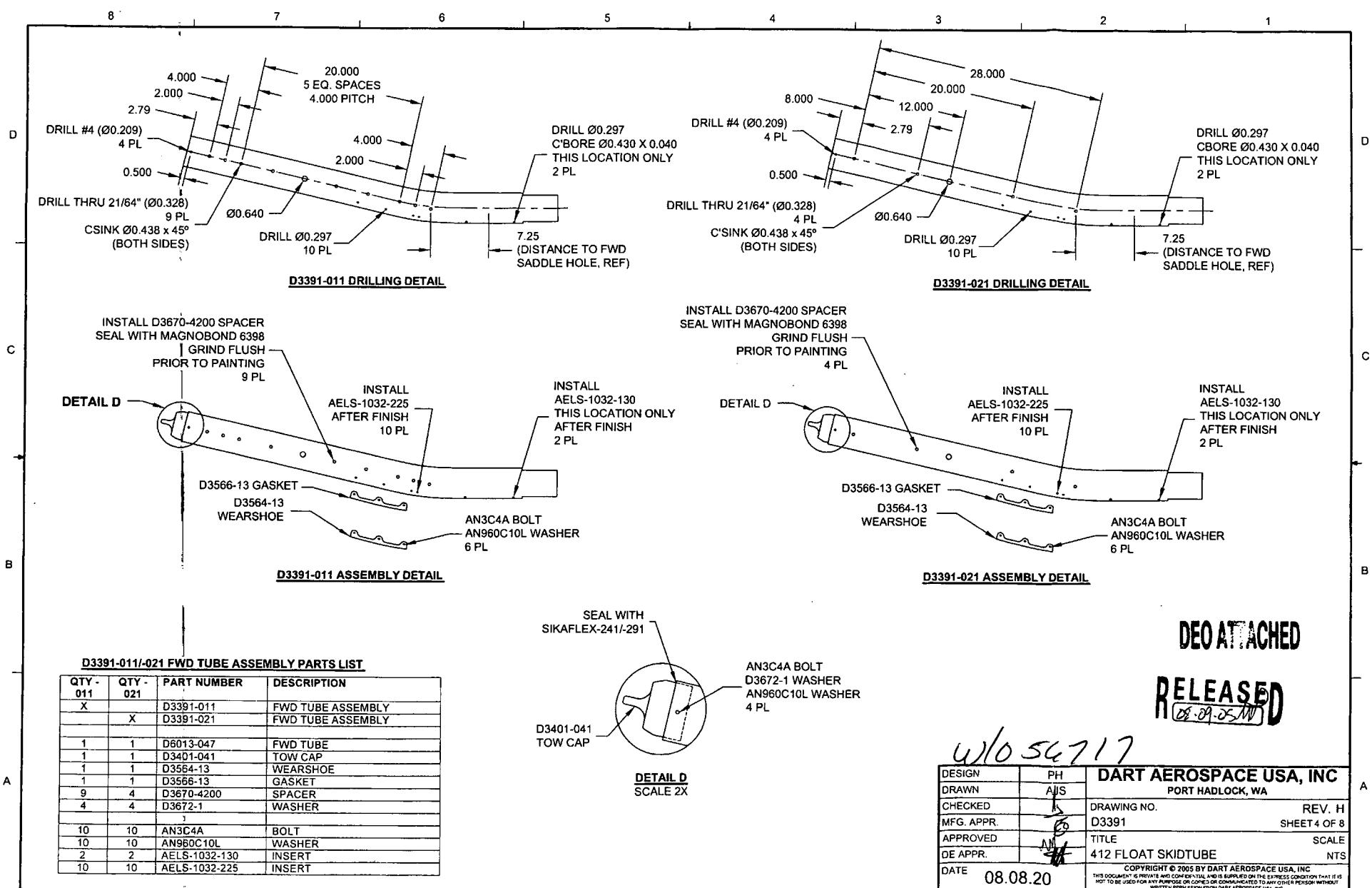
4

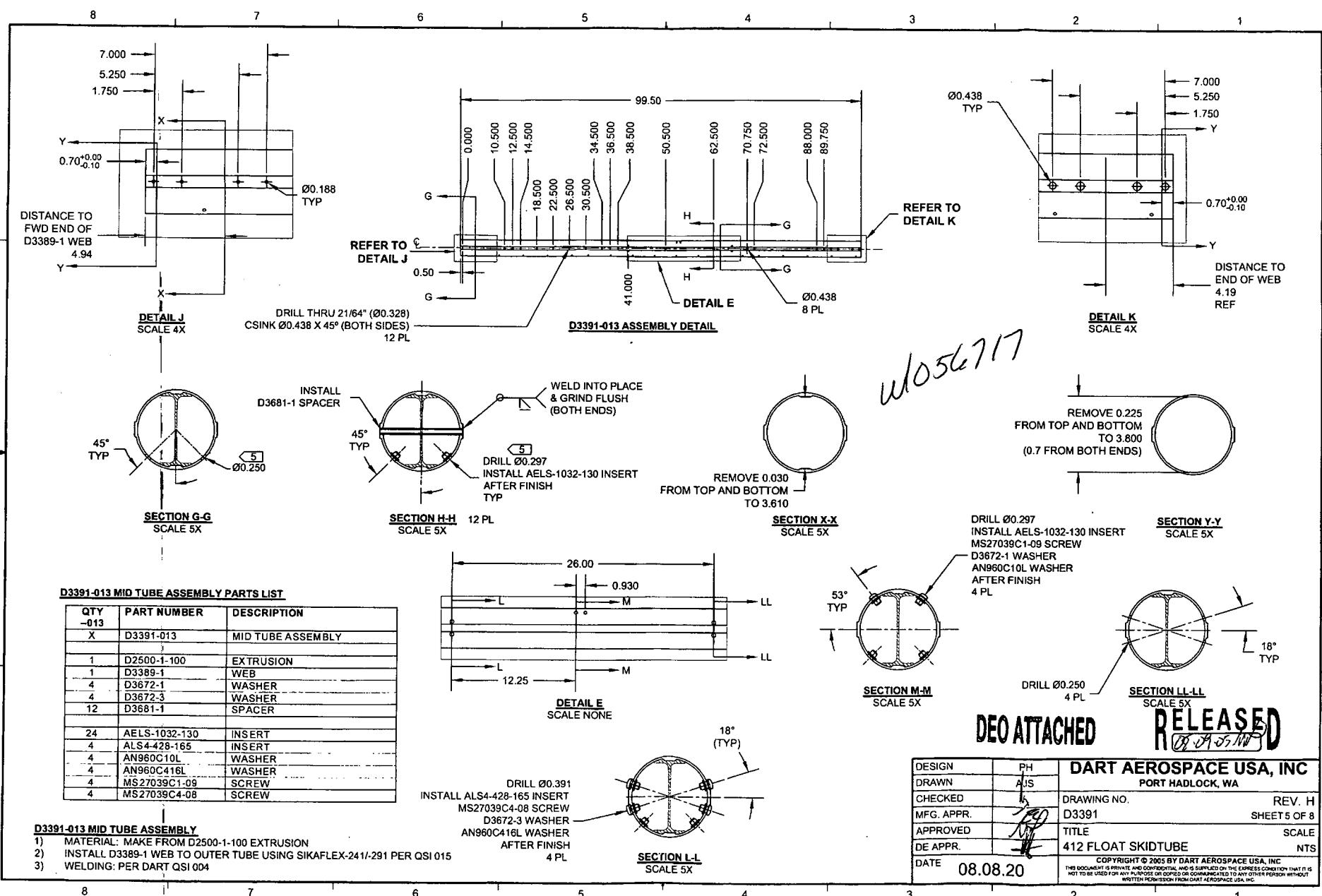
3

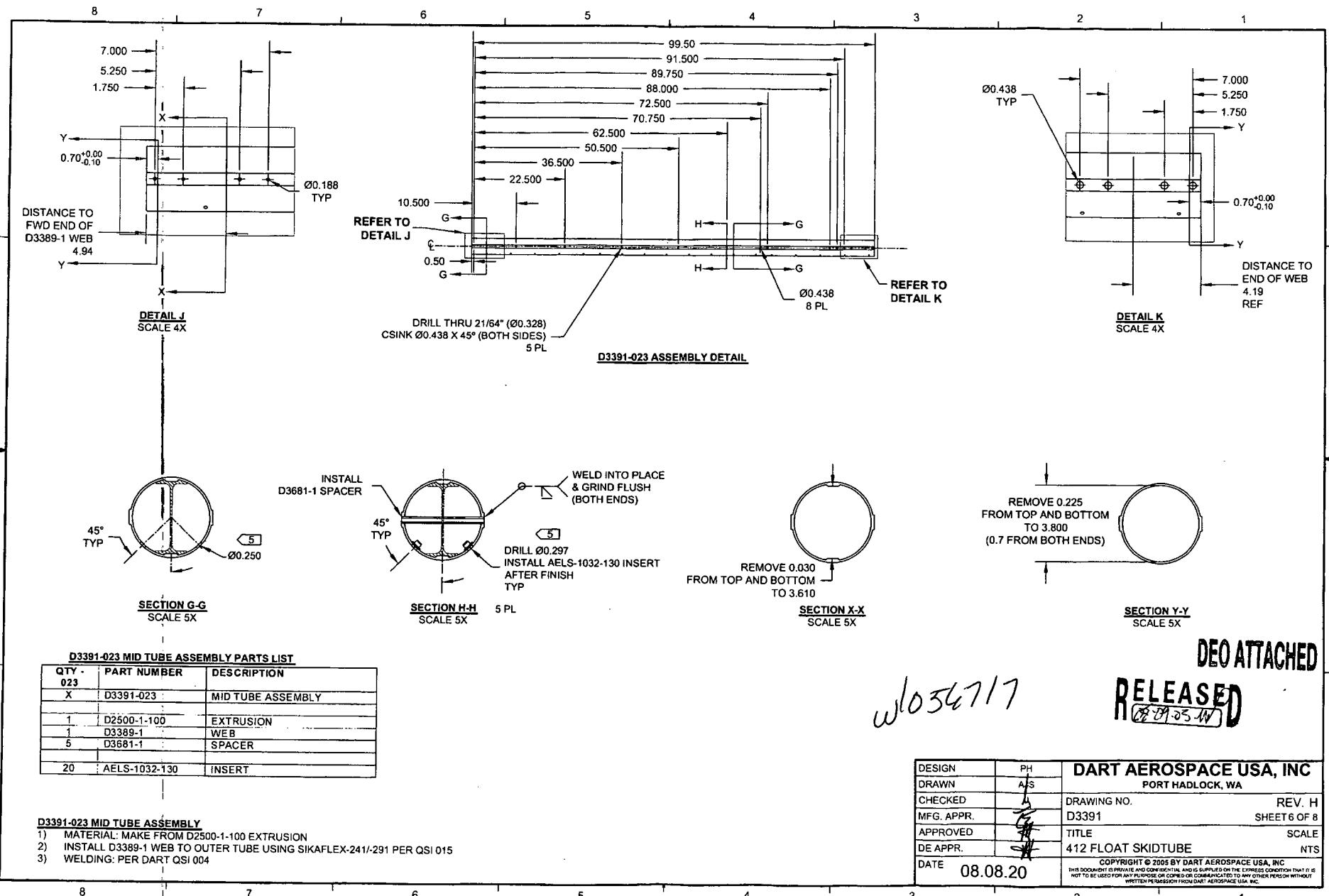
2

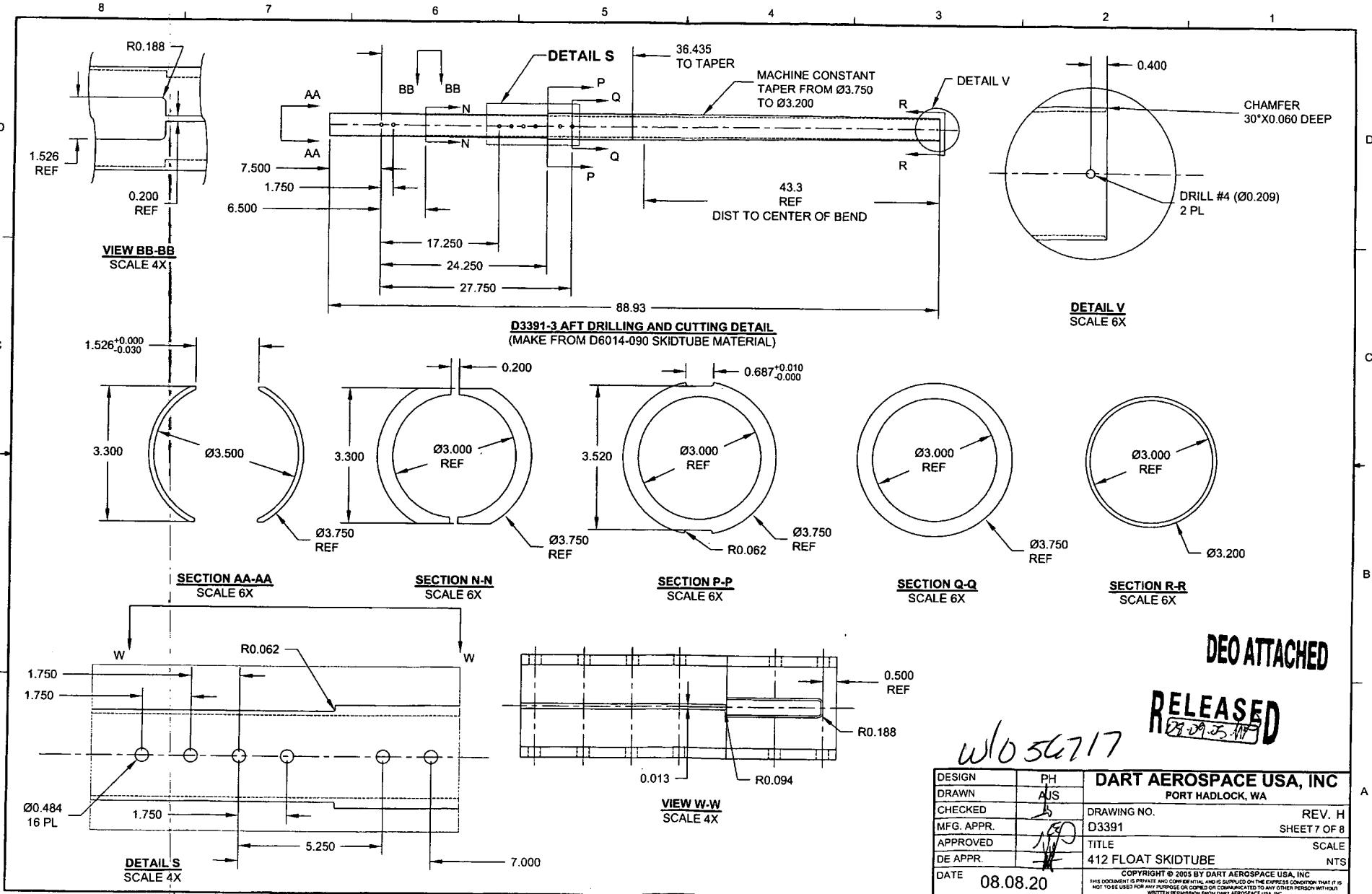
1

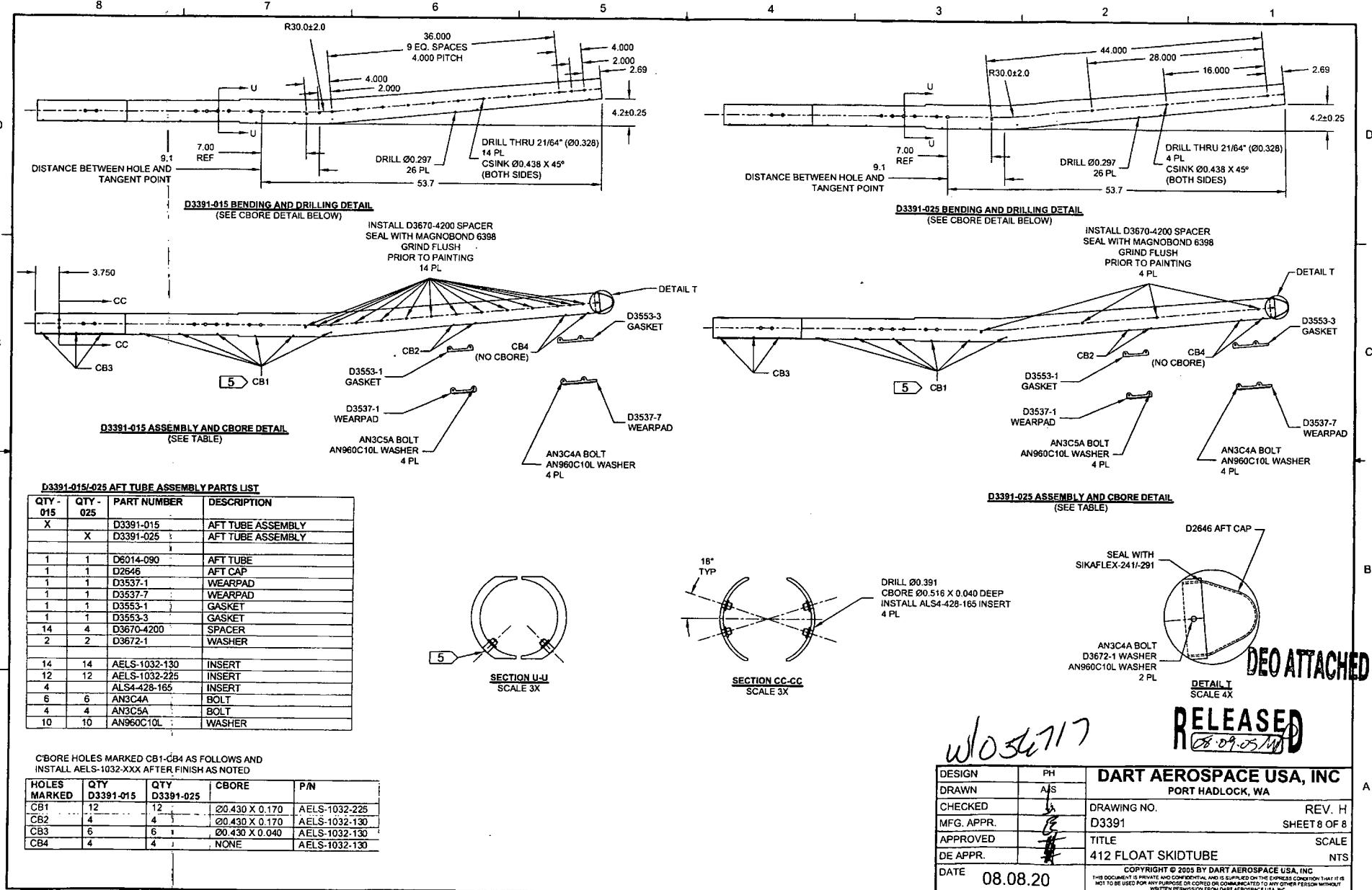
A











DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3391-H-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>CP</i>	CHECKED <i>AA</i>		MFG. APPR. <i>AA</i>	APPROVED <i>MD</i>	DE APPR. <i>#</i>		
DATE 09/09/23	DATE 09/09/24	DATE 09/09/25	DATE 09/09/25	DATE 09/09/30	DATE 09/09/30		

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH  
AND AFTER INSTALLATION OF INSERTS.~~ COAT ALL EXPOSED FASTENERS WITH  
LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS  
OFF POWDER COATING WITH MEK DEGREASER.

**RELEASED**  
2010-02-02

*MP*

*w/o 56717*